

Date: Wednesday, 12/20/2006 1:46:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 30049	
Estimate Number : 10001	
P.O. Number : <i>N/A</i>	Part Number : D2213
This Issue : 12/20/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2213 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25325	Material : <i>N/A</i>
Written By : <i>JF</i>	Due Date : 1/3/2007 Qty: 160 Um: Each
Checked & Approved By : <i>JF 06/12/20</i>	
Comment : Est Rev: C Turned In-House 05-10-17 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0750	6061-T6 Round Bar .750"
-----	--------------	-------------------------



Comment: Qty.: 1.1000 in(s)/Unit Total : 176.0000 in(s)
 MATERIAL:6061-T6 Round Bar .750"
 (M6061T6R0750)
 Batch: *419430*

JF 06/12/27

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA113 & DWG D2213,
 FOLIO REV: *A*
 DWG REV: *D*
 2-DEBURR AS REQUIRED

JF 06/12/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 06/12/27

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JM 06/12/28

167

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

07/12/02 6h 1m

166 psc

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:46:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 30049

Part Number: D2213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



im 07/01/02



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *St 29*

EB 07/01/02 *(165)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/02

Job Completion



C 207101103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

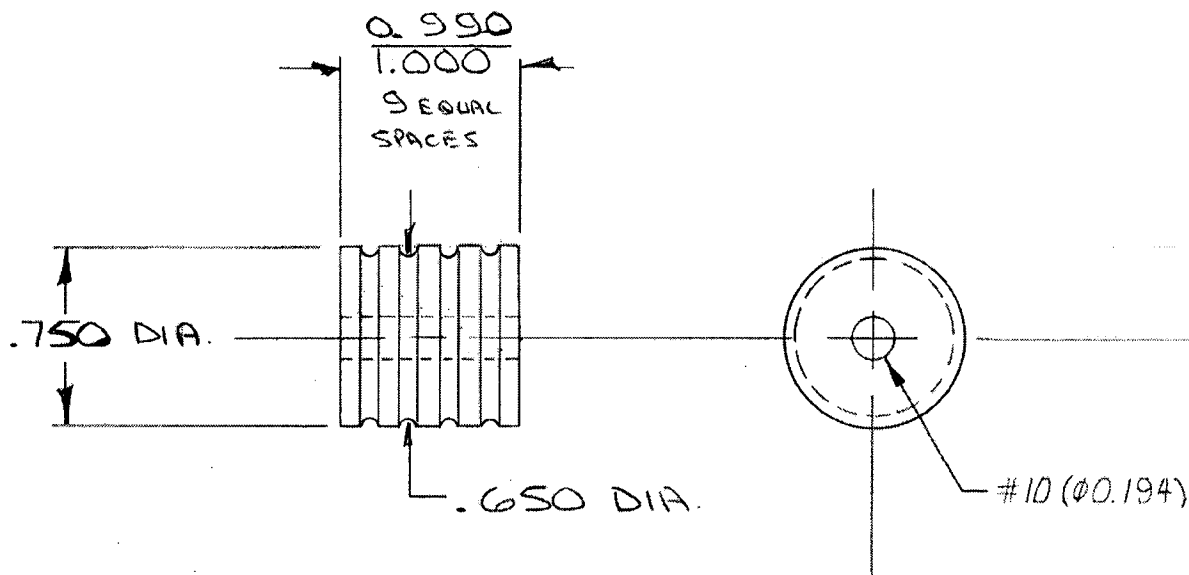
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DRAWN BRADLEY 94.2.9		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.2.9		DRAWING NO. DZZ13	REV. B
STRESS		TITLE SPACER	
B	95:08:17	#10 HOLE ADDED	



MATERIAL

ALUMINUM ALLOY 2011-T3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30049

42
42
42
20
166

~~12~~
~~3~~
~~4~~
42
~~4~~
25

12
~~15~~
—
39
4